










*SP1121*  
*21215*  
*NO SP1121*

Date: Thursday, 10/08/2006 10:01:04 AM  
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 28120 -1	
Estimate Number : 11483	
P.O. Number : <i>N/A</i>	Part Number : D2091
This Issue : 10/08/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2091REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 25264	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 08/09/2006 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: C 99.01.18 Re-format DM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	D2000043 Jet
 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Jet Pick: Qty Part Number Description Batch 1 D2000-043 Jet → <u>322741</u> → 9 <u>328128</u> → 1 <span style="float: right;">(10)</span>	
<i>CPL 06.11.20</i>	
2.0	<del>D2094</del> <i>D2094</i> Aspirators
 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Aspirator Pick: Qty Part Number Description Batch 1 <del>D2094</del> <i>D2094</i> Aspirator Body <u>328133</u>	
<i>CPL 06.11.20 (10)</i>	
3.0	D2095 Aspirator
 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Aspirator Pick: Qty Part Number Description Batch 1 <del>D2096</del> <i>D2095</i> Aspirator Core <u>315535</u>	
<i>CPL 06.11.20 (10)</i>	
4.0	LARGE FAB 1 LARGE FABRICATION RESOURCE 1
 	
Comment: LARGE FAB RESOURCE 1 Weld D2000-043 Jet to D2094 Aspirator Body as per Dwg D2091 using Jig DT8294 <span style="float: right;"><i>CPL 06.11.20</i></span>	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 28120

Part Number: D2091

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/06/11/20

(10)

6.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING

Issue P/O: 2520

c 20611121

Black Anodize weldment from step 3 and Dwg D2095

(10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ANODIZE

206-12-13

(9)

ASSYS

8.0

A1449

Grommet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Grommet

Pick:

Qty Part Number Description Batch  
4 A1449 Grommet

M1487

(X36)

ml

9.0

A1622

Grommet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Grommet

Pick:

Qty Part Number Description Batch  
4 A1622 Grommet

M1487

(X36)

ml

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Install grommets as per Dwg D2091

ml 06/12/12

(X9)

(PTD)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-12-14

(8)

6.1

Transit Damage

2006/12/08

(19)

PTD

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/12/13	6.1	<del>10 split for qty of</del> Add Receiving: Inspect for trans. + damage.  Permanent Change						
<del>06/12/13</del>	<del>10.0</del>	<del>Find 100 D2095 off on A1612 gramin. + fine in paper</del>						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/15  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/13	6.1	OK Good 1x D2094 weldment is missing from Andlize, or before Andlize. Remaining is 9x D2095 weldments: 10x D2095 Aspirator core.		See NCR 119, and I.D. stock 1x D2095 Aspirator core.	DB 06/12/13	06/12/13		
06/12/13	10.0	1 part scrap. → 1 gramin. + had to be replaced when it was removed the hole was enlarged. Scrap: destroyed. 1 part 2 graminets are no good.		change the 2 graminets, Scrap: destroy the 1 part.	SB 06/12/14	06/12/14		

NOTE: Date & initial all entries

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Drawing Name: ASPIRATOR

Job Number: 28120

Part Number: D2091

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST214*

*4 BQ / 12 / 14*

*(8)*

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Doc 112/15* *(8)*

Job Completion



*4 06-12-15*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**TNM****ANODISATION et PEINTURE TNM INC.**

C. OF C

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Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

51576

30-Nov-2006

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE****CERTIFICAT DE CONFORMITE****PURCHASE ORDER/****NO. DE COMMANDE: 00002520**

ITEM	COMMANDE / ORDER	DATE / DATE	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	19	19	D2091 B28120	AS PER DWG D2091 REV. A BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2

**REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL**

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.  
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: \_\_\_\_\_

☐ Directeur de la Qualité / Q.A. Manager ☐ ☐